

Work Order ID 86232

86232

Page 1

June-25-12 10:31:28 AM

Item ID: D3535-23

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearshoe

Start Date: 25/06/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 10/07/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/06/25

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3535

Rev B

(13)

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3535 Dwg Rev: B Prog Rev: B 2-
Deburr if necessary

304 1040

13

0

Jun 12-6-25

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

13

0

Jun 12-6-25

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

8/26/27

(17)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Item Name: Wearshoe

Start Date: 25/06/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 10/07/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	NC BRAKE	0.00							
130									
Brake NC	Memo	0.00				13			12/07/04
Brake NC	1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT83262-Form joggle as per Dwg D3535 using Jig DT81583-Identify as D3535-23								
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00				(+13)			
Quality Control									
150	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
150									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 7:40 OVEN TEMPERATURE: 320°F FINISH TIME: 8:10					13X			12/07/04

M121279

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Work Order ID 86232

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Page 3

Item ID: D3535-23

Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearshoe

Start Date: 25/06/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 10/07/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>FP7</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

13 ϕ 12.75

13X ϕ M-L
12/07/05

OK 12/7/06

MF
12-07-05

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NOTE: Date & initial all entries

Picklist Print

June-25-12 10:31:31 AM

Page 1

Work Order ID: 86232

86232

Parent Item: D3535-23

D3535-23

Parent Item Name: Wearshoe

Start Date: 25/06/2012

Required Date: 10/07/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	352.7693	1.3615	17.19789	20,		

M304S20GA

304/316 .040 Sheet

**

Jm 12-6-25

Location	Loc Qty	Loc Code
001	52.4914105	
121192	52.4914105	
MAT020	300.277922	
117933	27.3442	
118400	5.3723	
118964	23.2	
119346	24.8	
121380	49.761422	
121901	169.8	

12,901

(13)

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	<u>86232</u>
Description: Wearshoe		Part Number:	D3535-23
Inspection Dwg: D3535 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.882"	✓		V	mmol
2.000	+/-0.010	2.002"	✓		V	"
4.750	+/-0.010	4.744"	✓		V	"
9.500	+/-0.010	9.498"	✓		V	ProdW302
14.250	+/-0.010	14.250"	✓		MT	HB01
17.750	+/-0.010	17.750"	✓		MT	"
23.140	+/-0.010	23.140"	✓		MT	"
28.530	+/-0.010	28.530"	✓		MT	"
33.920	+/-0.010	33.920"	✓		MT	"
39.310	+/-0.010	39.310"	✓		MT	"
44.700	+/-0.010	44.700"	✓		MT	"
48.200	+/-0.010	48.200"	✓		MT	"
52.850	+/-0.010	52.850"	✓		MT	"
Ø0.188	+0.005/-0.001	0.190"	✓		V	mmol
48.00	+/-0.030	48.00"	✓		MT	HB01
39.00	+/-0.030	39.00"	✓		MT	"
32.00	+/-0.030	32.00"	✓		MT	"
24.00	+/-0.030	24.00"	✓		MT	"
16.00	+/-0.030	16.00"	✓		MT	"
8.00	+/-0.030	8.7998"	✓		V	mmol
6.00	+/-0.030	5.995"	✓		V	"
0.300	+/-0.010	0.304"	✓		V	"
0.300	+/-0.010	0.305"	✓		V	"
0.038	+/-0.010	0.036"	✓		V	"

Measured by:	<u>Sm</u>	Audited by:	<u>S</u>	Prototype Approval:	N/A
Date:	<u>12-6-25</u>	Date:	<u>12/09/27</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	KJ/EC/DD	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

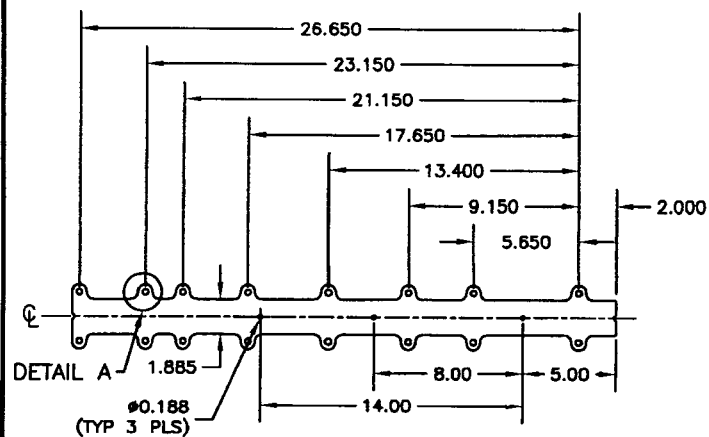
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

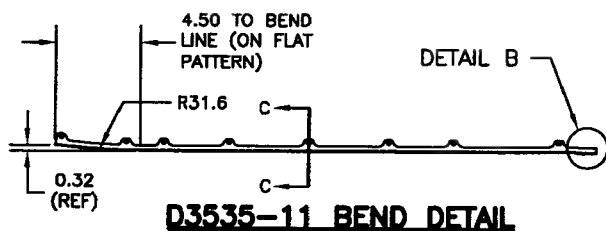
DART

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07.04.24

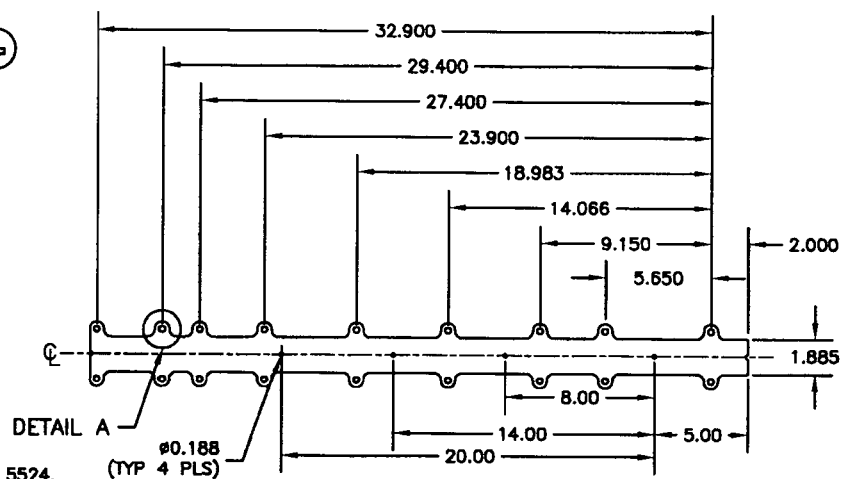
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86232 445
12/06/25



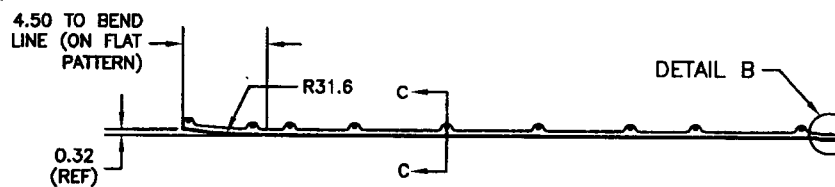
D3535-11F FLAT PATTERN



D3535-11 BEND DETAIL



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
PH	PH	D3535
DATE	TITLE	REV. B
07.04.17	WEARSHOE	SHEET 1 OF 7
A	06.10.25	NEW ISSUE
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

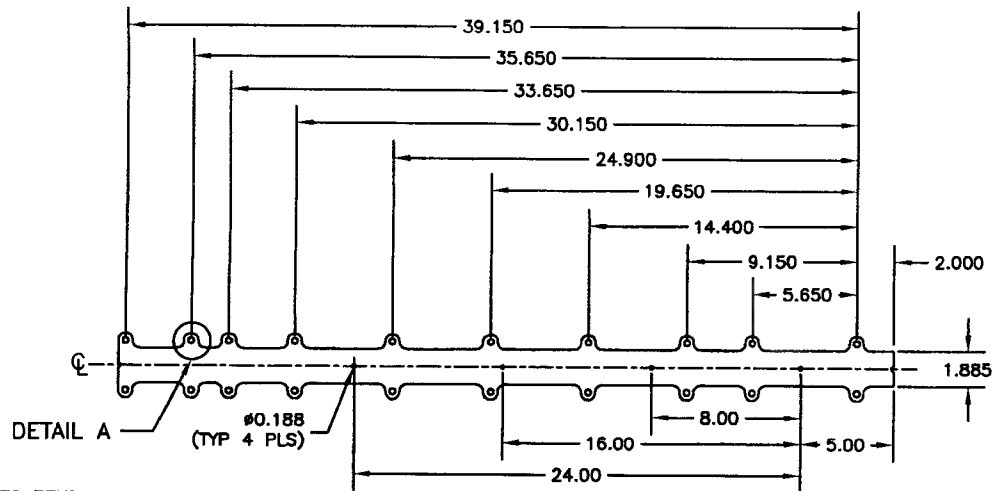
NOTE: Date & initial all entries

86232

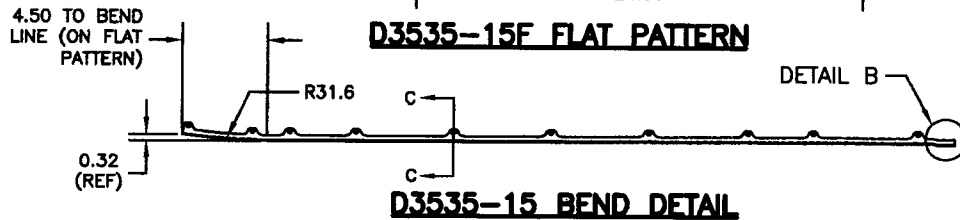
DART

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07.04.24

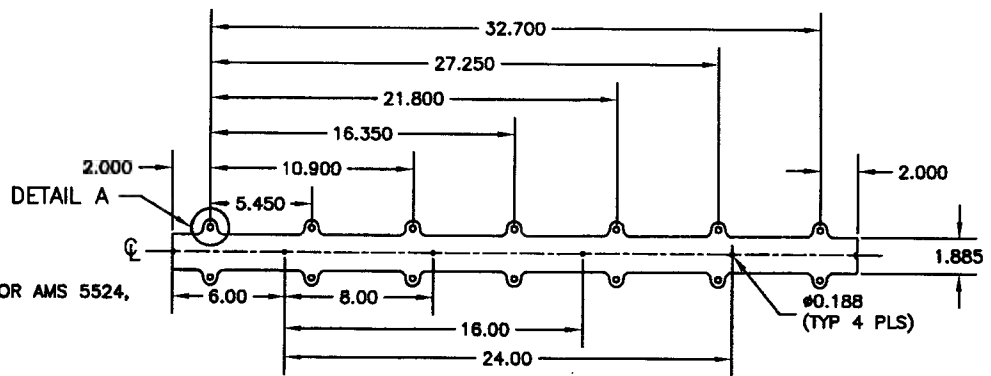
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CHECKED		APPROVED		PORT HADLOCK, WA
DATE	07.04.17	TITLE	D3535	WEARSHOE
		DRAWING NO.	D3535	
		REVISION	B	
		SHEET	2 OF 7	
		SCALE	1:10	



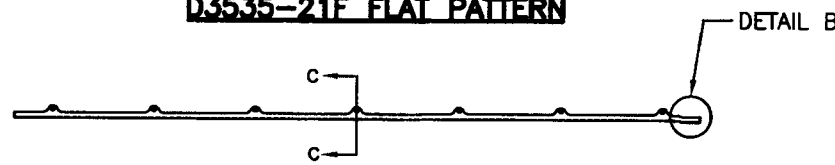
D3535-15F FLAT PATTERN



D3535-15 BEND DETAIL



D3535-21F FLAT PATTERN



D3535-21 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

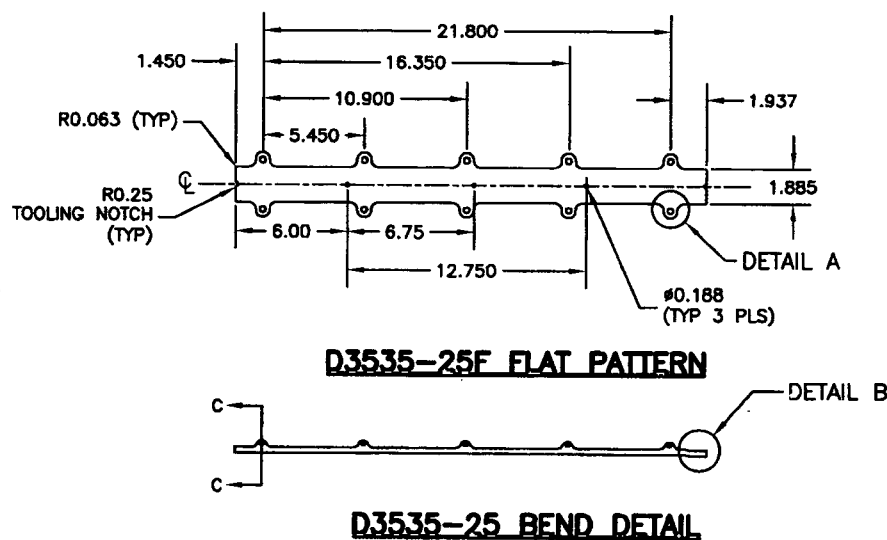
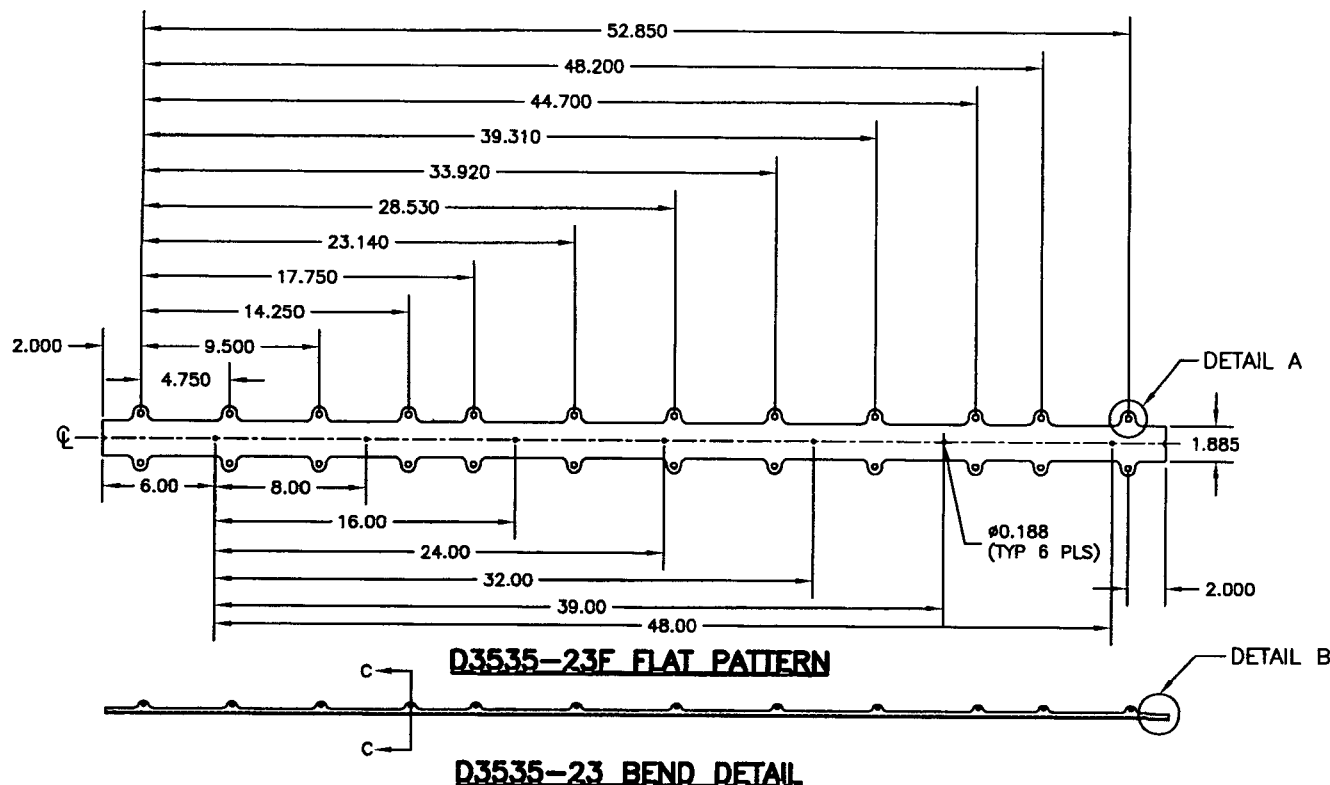
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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DESIGN	C.B.	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	07.04.17	TITLE	D3535	WEARSHOE
				SCALE 1:10
				SHEET 3 OF 7
				REV. B

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

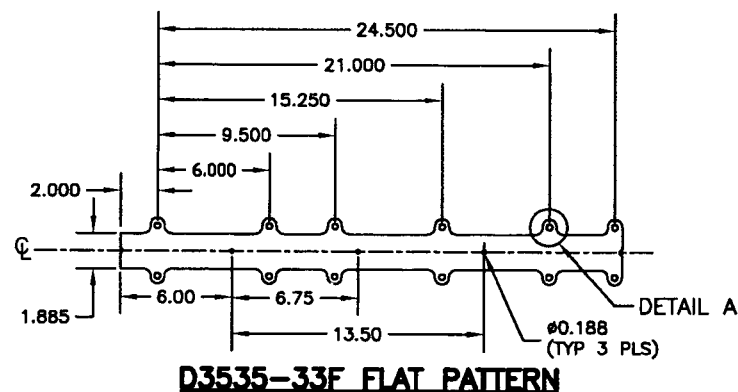
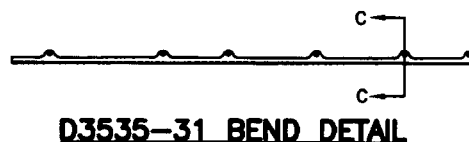
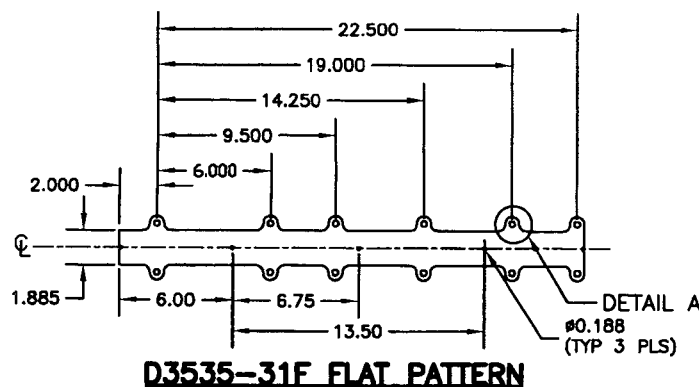
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CHECKED 	APPROVED 	DRAWING NO. D3535	REV. B
DATE 07.04.17	TITLE WEARSHOE	SHEET 4 OF 7	SCALE 1:10

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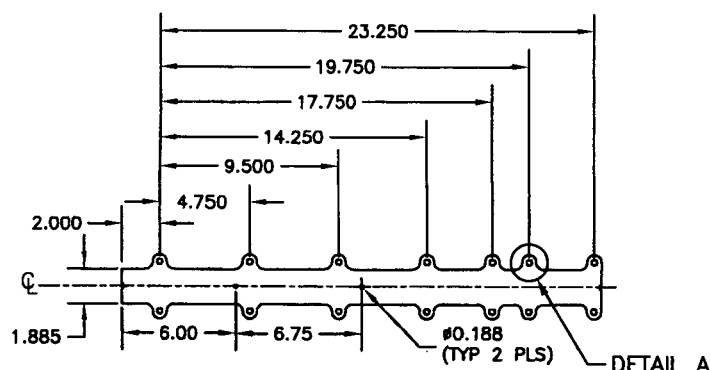
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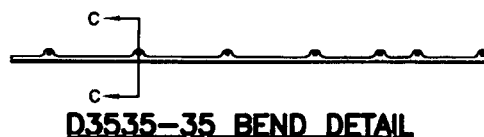
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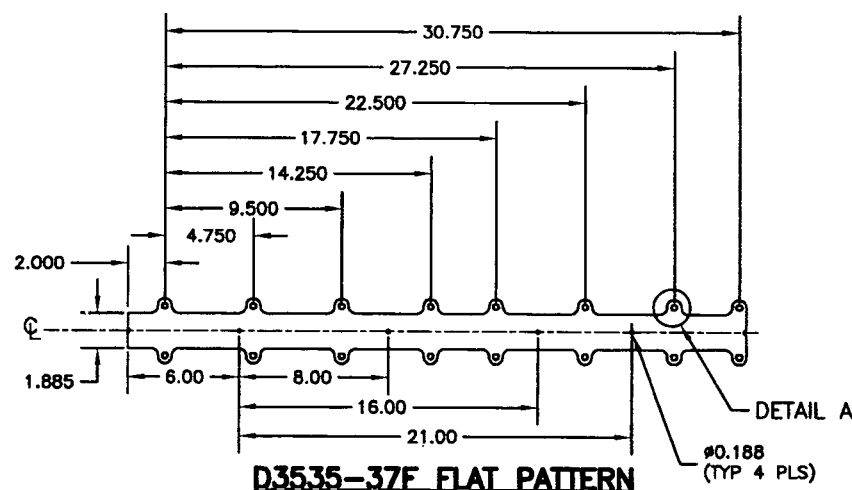
RELEASED
07.04.17



D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
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CHECKED		APPROVED		PORT HADLOCK, WA
DATE	07.04.17	TITLE	D3535	WEARSHOE
		DRAWING NO.	D3535	
		SHEET 5 OF 7		
		SCALE	1:10	

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

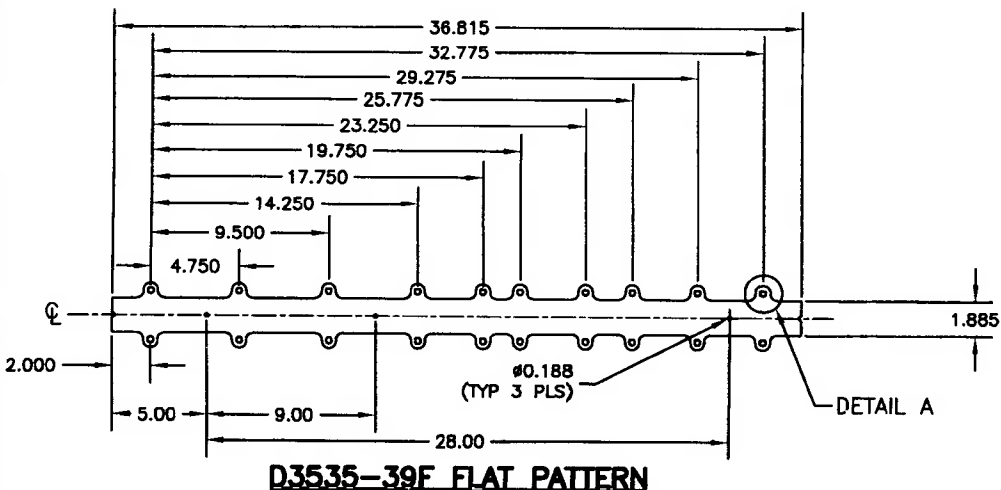
NOTE: Date & initial all entries

86.232

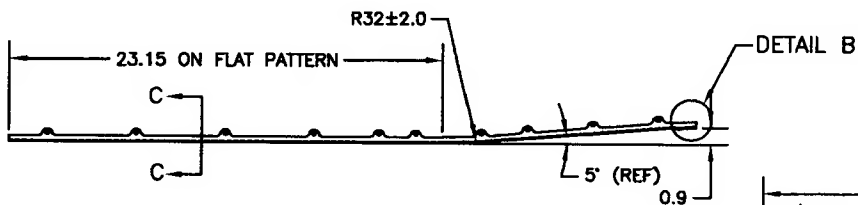


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07.04.24

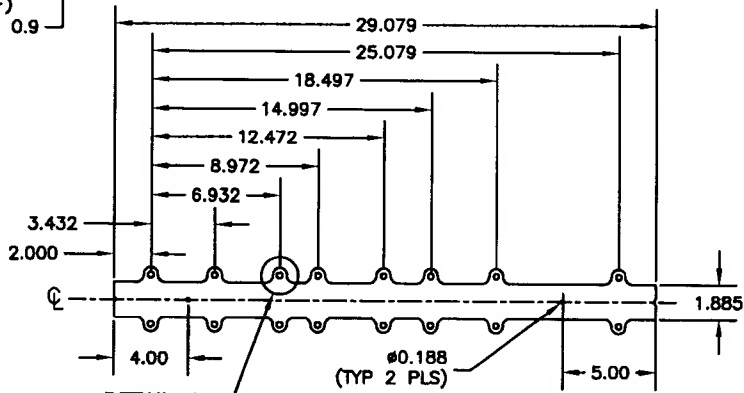
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CHECKED 	APPROVED 	DRAWING NO. D3535
DATE 07.04.17	TITLE WEARSHOE	REV. B SHEET 6 OF 7
	SCALE 1:10	



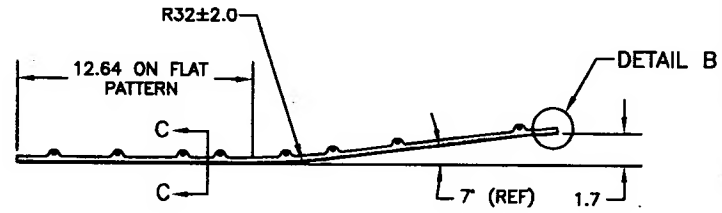
D3535-39F FLAT PATTERN



D3535-39 BEND DETAIL



D3535-41F FLAT PATTERN



D3535-41 BEND DETAIL

NOTES

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- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

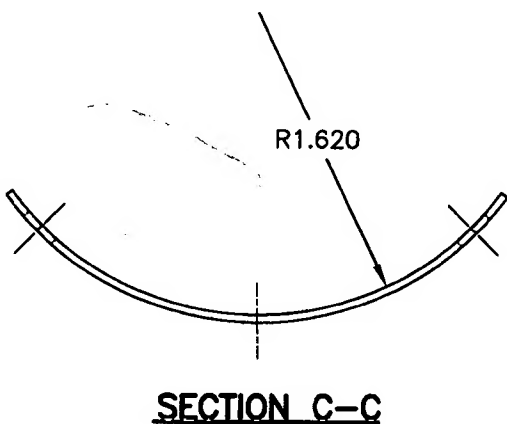
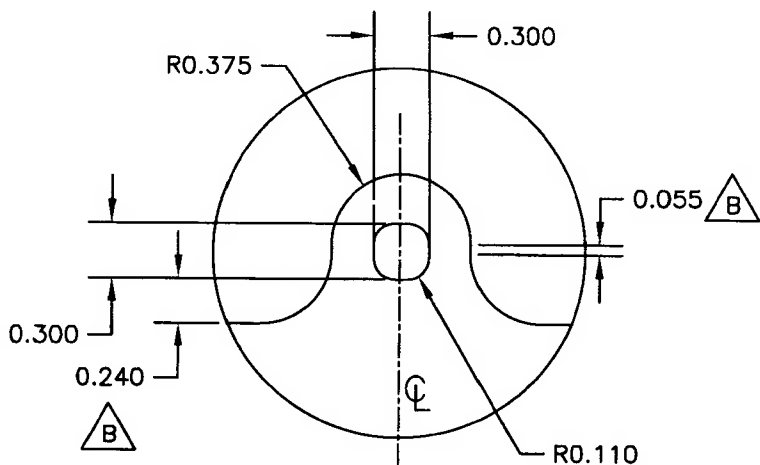
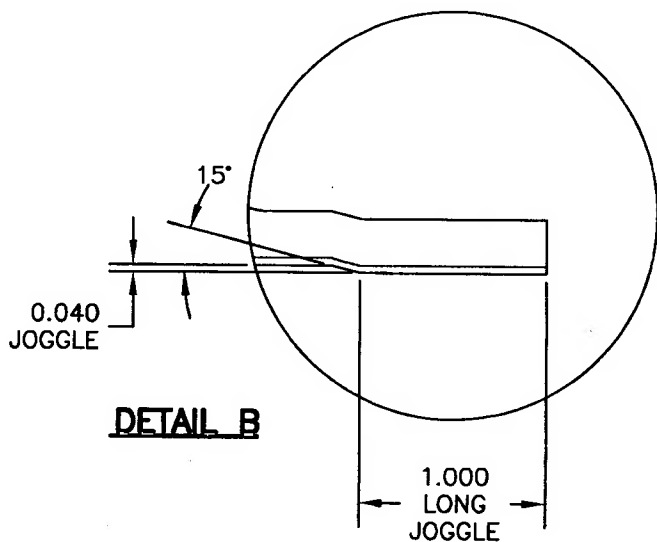
NOTE: Date & initial all entries

26232



DESIGN	C.B.	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 7 OF 7
		SCALE	1:1	

RELEASED
07.04.24



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries